

**Work Order ID 58137**

April 26, 2010 11:09:56 AM

Page 1

Item ID: D4095-041

Revision ID: PRELIM

Item Name: Wearplate Assembly

Start Date: 4/26/10 Start Qty: 2.00

Required Date: 4/26/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *U*

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4095

PA3

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond gasket to inner surface of waerplate as per dwg  
A/R 3M Scotch grip adhesive Batch:*M113174*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

**PRELIMINARY ISSUE**

Accept

Setup Start

Stop

Cust Item ID:

Customer:

*JB 10.04.26**AD 100426**JB 10.04.26**2*

**Work Order ID 58137**

April 26, 2010 11:09:56 AM



Page 2

Item ID: D4095-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Wearplate Assembly

Start Date: 4/26/10 Start Qty: 2.00



Cust Item ID:

Required Date: 4/26/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

58164

0.00

Packaging

10.04.20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/07

mf  
10-4-07

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE 10.10.07

April 26, 2010 11:09:55 AM

Page 1

[illegible]**Start Date:** 4/26/10**Required Date:** 4/26/10

**Start Qty: 2.00**

**Required Qty: 2.00**

[illegible]

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

D

D

C

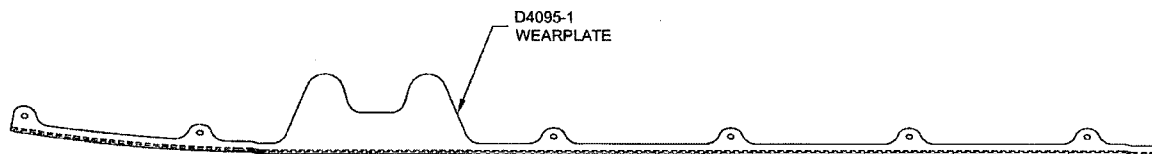
C

B

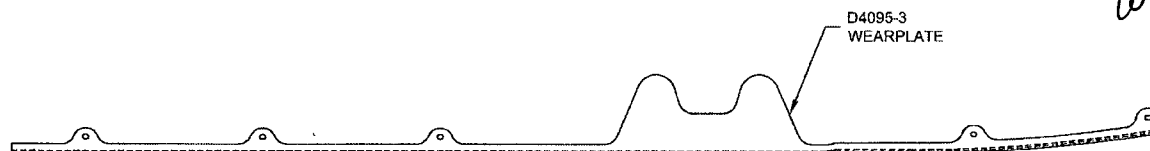
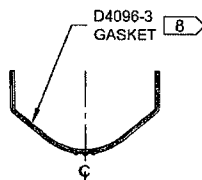
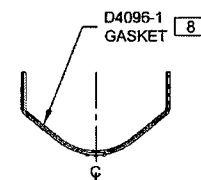
B

A

A







△ D4095-041 WEARPLATE ASSEMBLY



△ D4095-043 WEARPLATE ASSEMBLY

W/O 58137

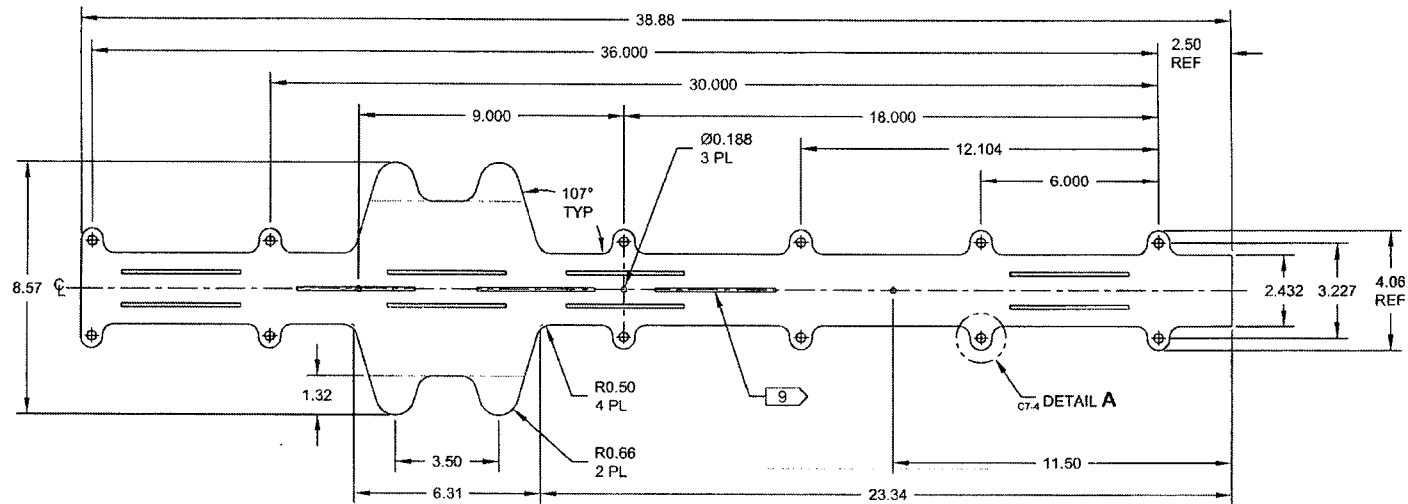
PRELIMINARY ISSUE  
10.04.23

PA3	ADDED D4095-041/-043; 20.35 WAS 20.69 (ZN C6-3); DIM 2.80 REF WAS 2.72 (ZN B6-4)	MB	10.04.23
PA2	ADDED CLEARANCE FOR INSIDE SADDLE INCREASED EDGE DISTANCE ON SAME PROFILE	MB	10.04.22
PA1	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D4095</div> <div>TITLE WEARPLATE</div> <div>REV. PA3</div> <div>SHEET 1 OF 4</div> <div>SCALE NTS</div> <div>COPYRIGHT © 2010 BY DART AEROSPACE LTD</div> <div><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small></div>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.23		

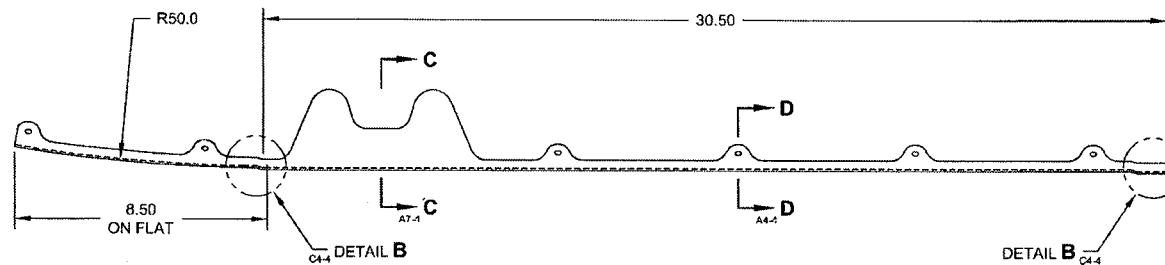
**D4095-041/-043 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

8 7 6 5 4 3 2 1



**D4095-1F FLAT PATTERN** 1



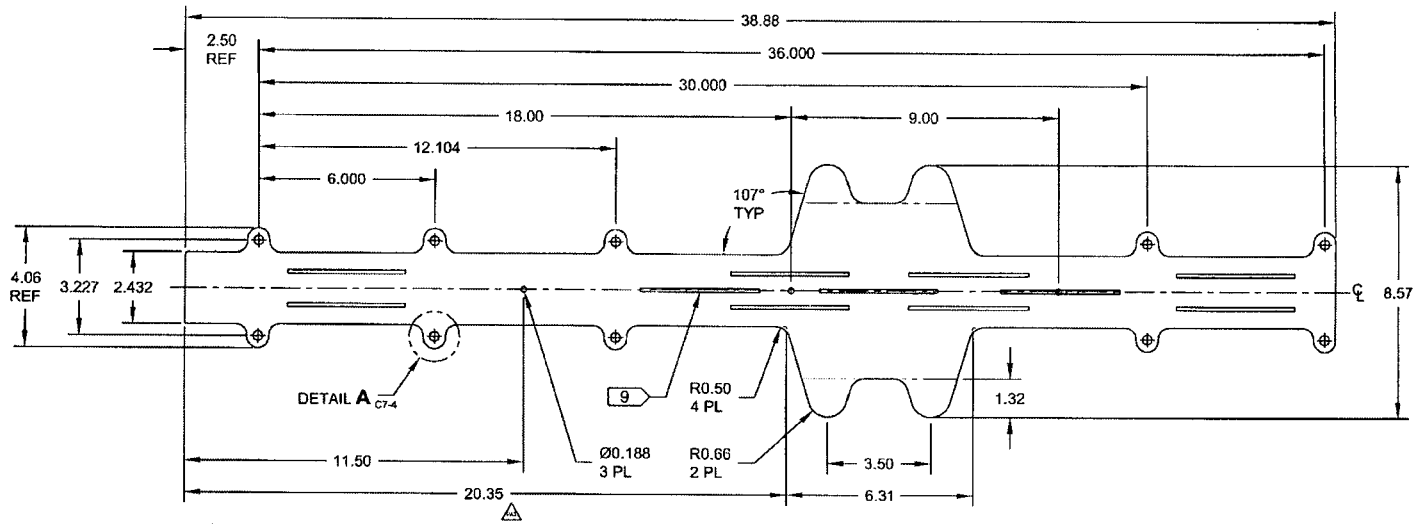
**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

**D4095-1/-1F/-3/-3F NOTES:**

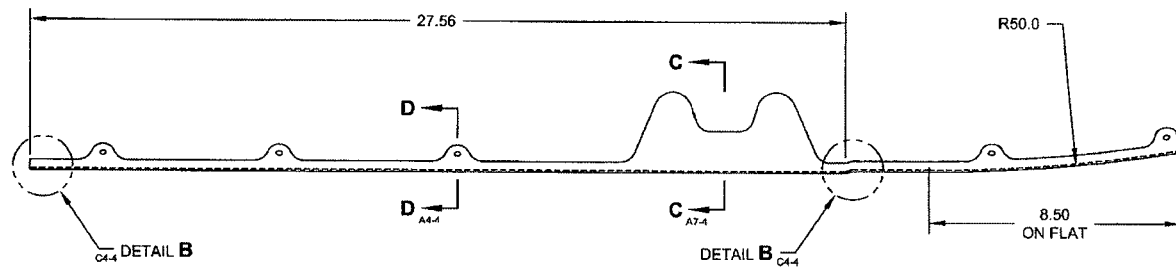
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.063 TO 0.125 HIGH, 11 PL  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

PRELIMINARY ISSUE  
10.04.23

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4095	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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**D4095-3F FLAT PATTERN** [1]

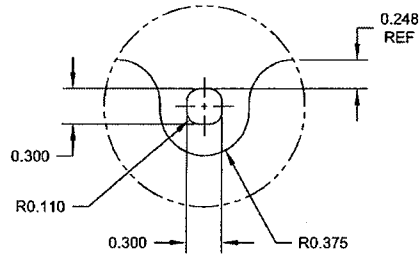


**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

WLD  
58137

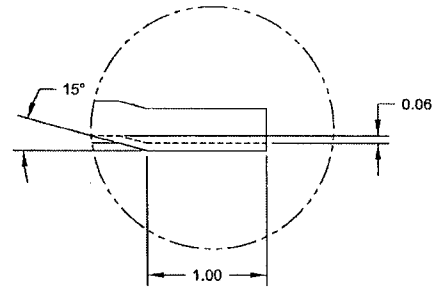
PRELIMINARY ISSUE  
10.04.23

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA3
MFG. APPR.		D4095 SHEET 3 OF 4
APPROVED		TITLE SCALE
DE APPR.		WEARPLATE NTS
DATE	10.04.23	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD



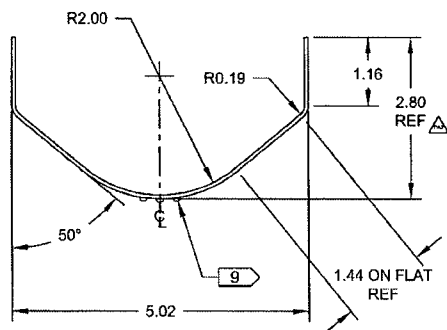
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-2  
C6-3



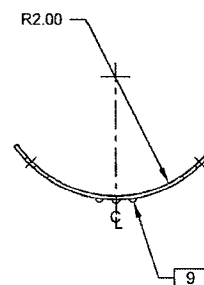
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-2  
B8-2  
B4-3  
B7-3



**SECTION C-C**

SCALE 2X  
B5-2  
B4-3



**SECTION D-D**

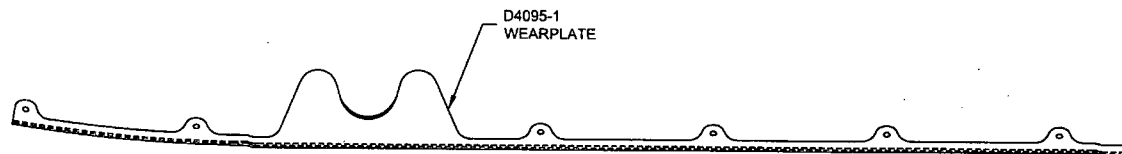
SCALE 2X

*WLO 58187*

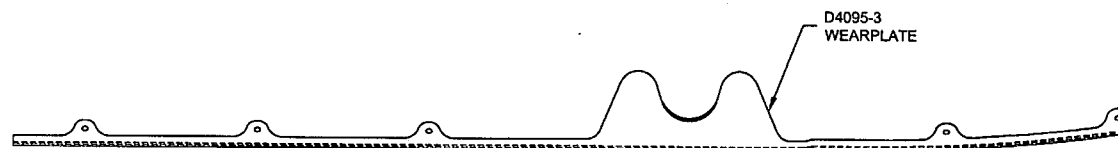
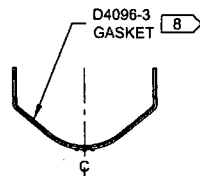
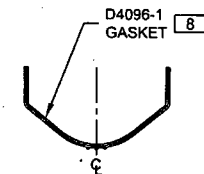
PRELIMINARY ISSUE  
10.04.23

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D4095-041	WEARPLATE ASSEMBLY
2		X	D4095-043	WEARPLATE ASSEMBLY
3	1		D4095-1	WEARPLATE
4		1	D4095-3	WEARPLATE
5	1		D4096-1	GASKET
6		1	D4096-3	GASKET
7	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE



**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**

**RELEASED**  
2010-09-07  
N/A

58137

**D4095-041/-043 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-04X" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4095-041 = 2.60 lbs; D4095-043 = 2.58 lbs
- 8) AFTER FINISH, BOND GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 9) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	J		
DRAWN	J		
CHECKED	P		
MFG. APPR.	D		
APPROVED	19		
DE APPR.	#		
DATE	10.04.20		

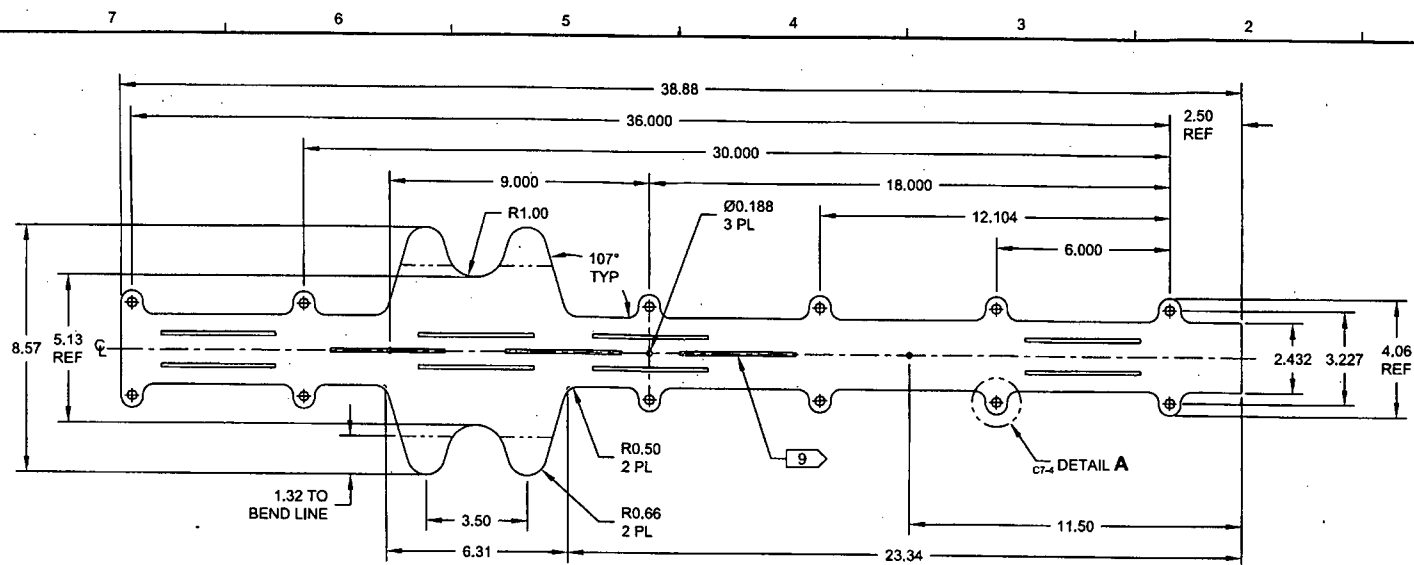
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4095  
REV. A  
SHEET 1 OF 4

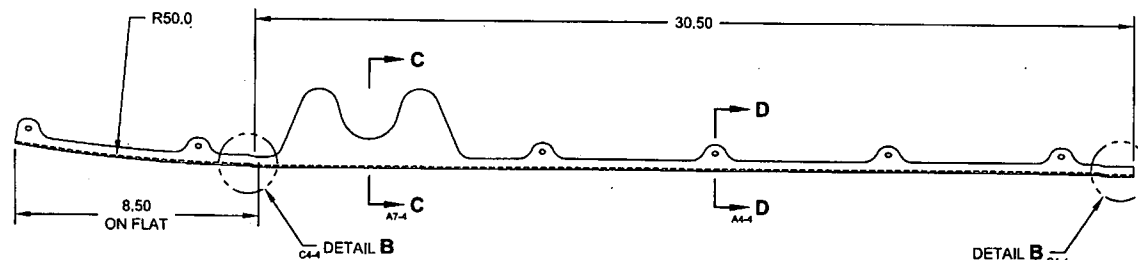
TITLE WEARPLATE  
SCALE NTS

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**D4095-1F FLAT PATTERN** 1



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

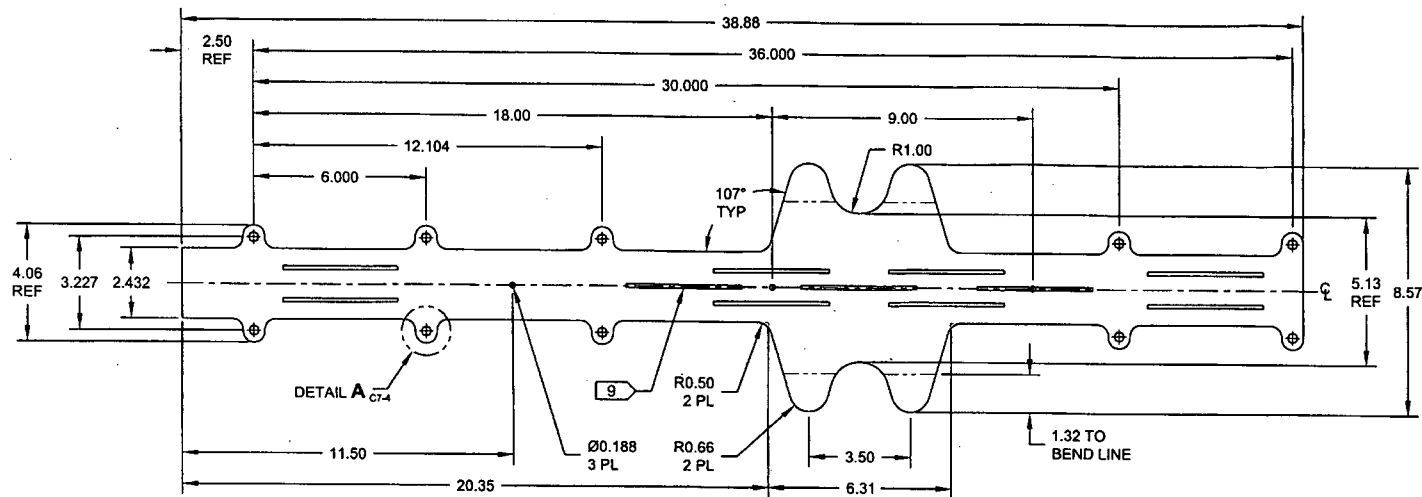
**D4095-1/-1F/-3/-3F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: POWDER COAT GREY SANDEXT (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 2.18 lbs; D4095-3 = 2.16 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD: 4.0 LONG X 0.125 HIGH, 11 PL  
WELD AFTER BENDING AS ILLUSTRATED PER DT8308
- 10) PARTS ARE SYMMETRIC ABOUT C

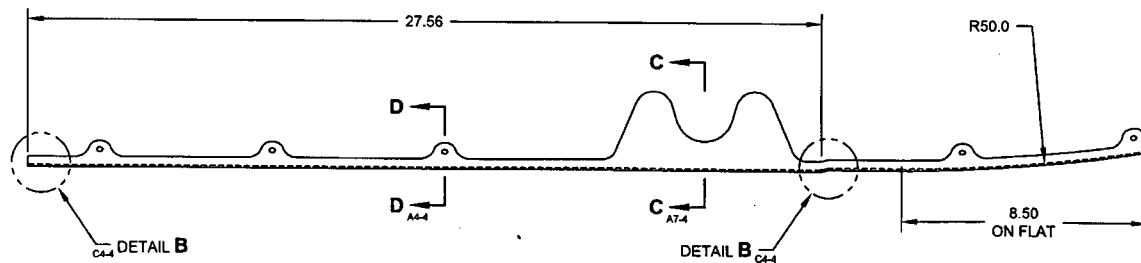
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DRAWN	1		
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D4095	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	WEARPLATE	NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
2010-08-07






58137



**D4095-3F FLAT PATTERN** 1

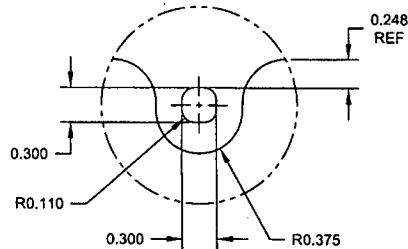


**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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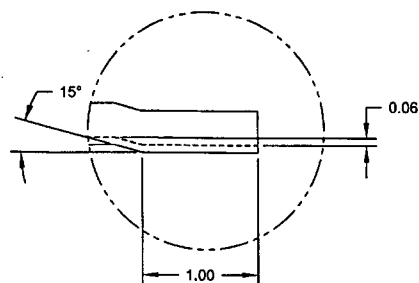
RELEASED  
2010-09-07  
VMD

58137



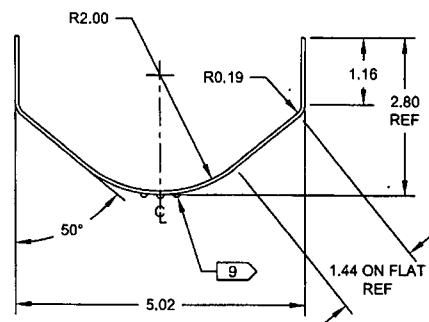
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-2  
C8-3



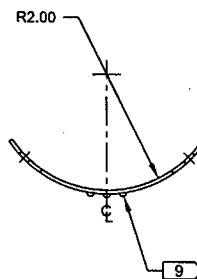
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-2  
B5-2  
B4-3  
B7-3



**SECTION C-C**

SCALE 2X  
B5-2  
B4-3



**SECTION D-D**

SCALE 2X

58137

**RELEASED**  
2010-09-07  
JMS

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4095	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	10.04.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Location/Lot Activity

October 7, 2010 1:32:10 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 58137 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D4095-041 / Wearplate Assembly	Main Warehouse ENG	58164	FAUT01		2.0000		2.0000		
					4/27/10	-2.0000	58137	-2.0000		-\$254.12
								-2.0000		-\$254.12
WIP Receipt	D4095-041 / Wearplate Assembly	Main Warehouse ENG	58137	FAUT01		0.0000		0.0000		
					4/27/10	2.0000	58137	2.0000		\$254.12
								2.0000		\$254.12